

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004369**Date Inspected:** 24-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** Yes No N/A**Rod Oven in Use:****Yes No N/A****Electrode to specification:** Yes No N/A**Weld Procedures Followed:****Yes No N/A****Qualified Welders:** Yes No N/A**Verified Joint Fit-up:****Yes No N/A****Approved Drawings:** Yes No N/A**Approved WPS:****Yes No N/A****Delayed / Cancelled:****Yes No N/A****Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Side & Bottom Plates	NA	NA	QA-MT

OBG

Bay 4: Caltrans QA inspector performed magnetic particle test (MT) inspection per ZPMC notification of witness inspection, document number 001268. The subassemblies are identified as side plates, weld SP433-001-001, 003, 005 007, 009; SP764-001-001, 003, 005, 007, 009, 011 and SP442-001-001 003, 005, 007, 009, 011 weld cover pass.

Caltrans QA inspector observed that the cover pass welds have been MT inspected and identified as accepted by ZPMC QC-MT inspector, Mr. Cai Xin Xin. Caltrans QA-MT coverage was approximately 10%. The welds were found to be in compliance with the project specifications. Caltrans QA inspector also performed (MT) inspection per ZPMC notification of witness inspection, document number 001273. The subassemblies are identified as side plates, weld SP097-001-015, 017, 019, 021, 023, 025, 027; SP151-001-013, 015, 017, 019, 021, 023 and bottom plate, welds BP172-001-007, 009, 011, 013, 015 and 017 weld cover pass. Caltrans QA inspector observed that the cover pass welds have been MT inspected and identified as accepted by ZPMC QC-MT inspector, Mr. Wang Wei. Caltrans QA-MT weld coverage was approximately 10%. The welds appeared to be in conformance with the project specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated, October 24, 2008 for additional information.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

As identified within the contents of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, 138-1694-2685, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer

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